

Date: Wednesday, 12/14/2005 4:03:12 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 25241		
Estimate Number	: 10379		
P.O. Number	: N/A	Part Number	: D3195041
This Issue	: 12/14/2005 S.O. No. : N/A	Drawing Number	: D3195 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 25098	Material	: N/A
Written By	: See Comment below	Due Date	: 1/10/2006
Checked & Approved By	: See Comment below	Qty:	10 Um: Each
Comment	: Est Rev:A New Issue 05-11-08 JLM		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B0750X02000

6061-T6 Bar .75" x 2.0"



Comment: Qty.: 0.3150 f(s)/Unit Total : 3.1500 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11)

(M6061T6B0.750x02.000)

Identify for D3195-1

Batch: M9601

J.G 05/12/16 10

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks: (0.75" x 2.00") x 3.60" long

m 05/12/16 10

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine D3195-1 as per Folio FA334 and Dwg D3195

Identify as D3195-1

Deburr

E. 05/12/16 10

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

m 05/12/16 10

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BG 05.12.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/14/2005 4:03:12 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 25241

Part Number: D3195041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 12/12/05 10

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 06 01 11 10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

u 06 01 11 10

9.0

D31955

Pad



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3195-5 PAD B25114

SA 06/01/12 10

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond D3195-5 into D3195-1 as per Dwg D3195Pick:

Qty Description Batch

A/R Contact Cement M46194

Identify as D3195-041

SA 06/01/12 10

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

u 06-01-12 10

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 90

C 206/01/12 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: RF Date: 06/01/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/14/2005 4:03:12 PM  
User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 25241

Part Number: D3195041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

*SP* 02/01/12

Job Completion



*W* 06-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

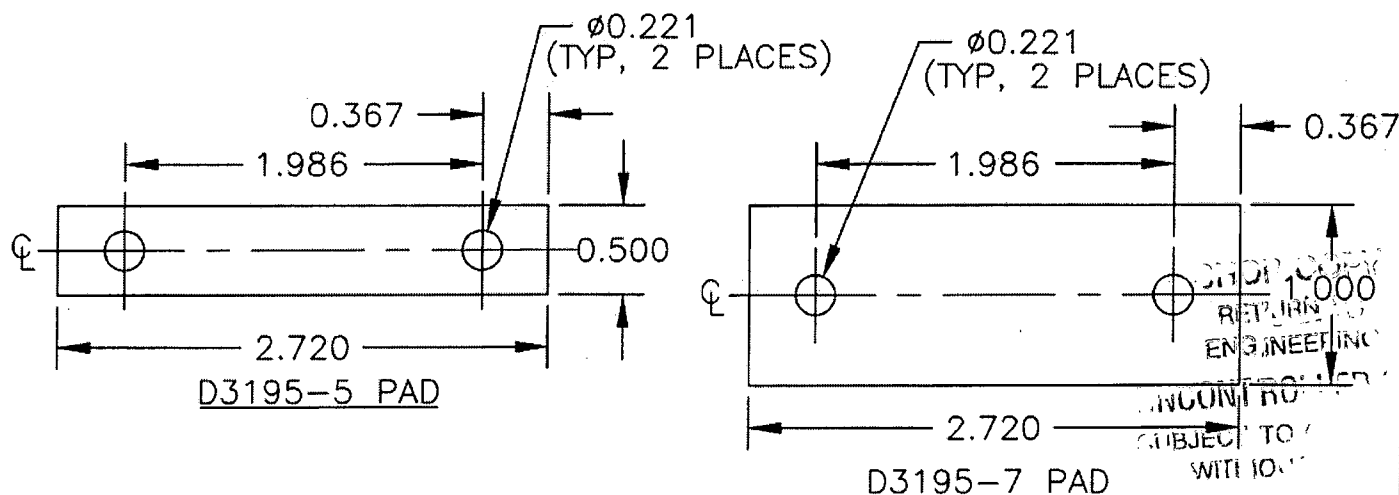
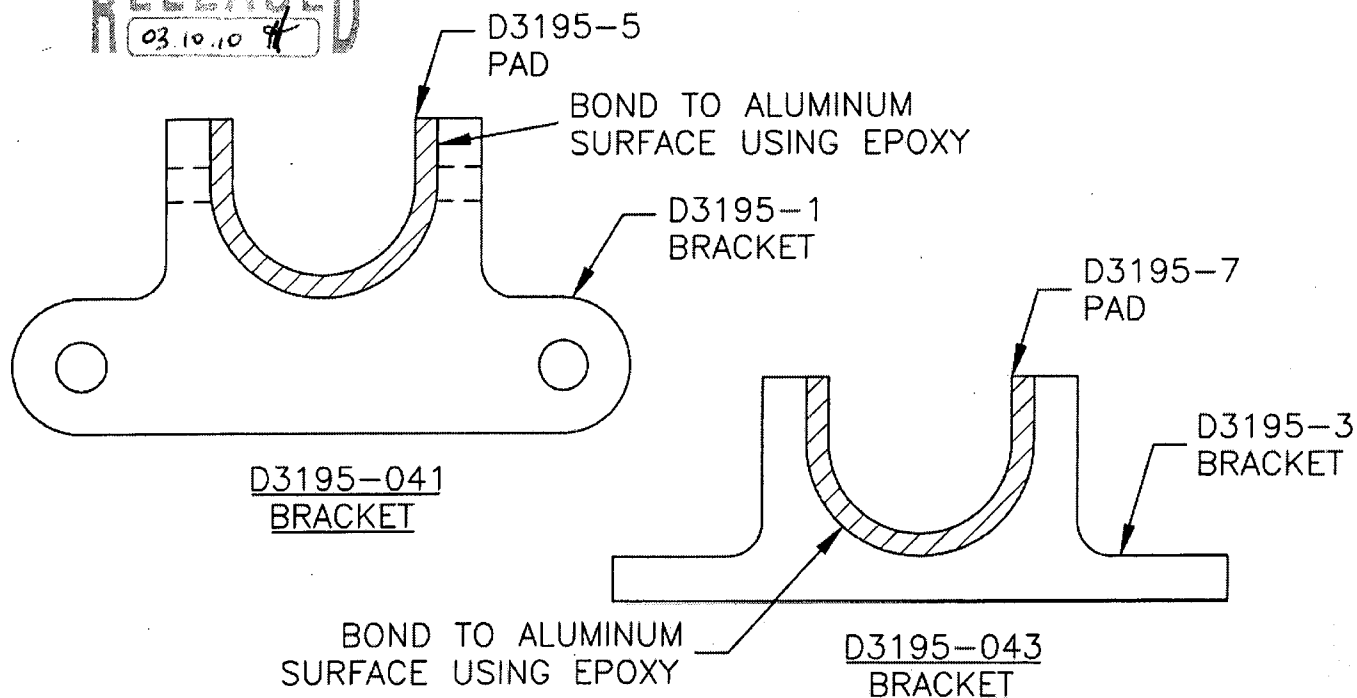
NOTE: Date & initial all entries





DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. A
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	SHEET 1 OF 3
				D3195	
DATE	03.06.23			TITLE	SCALE
				BRACKET	1:1
A	03.06.23			NEW ISSUE	

RELEASED  
03.10.10



#### D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK  
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

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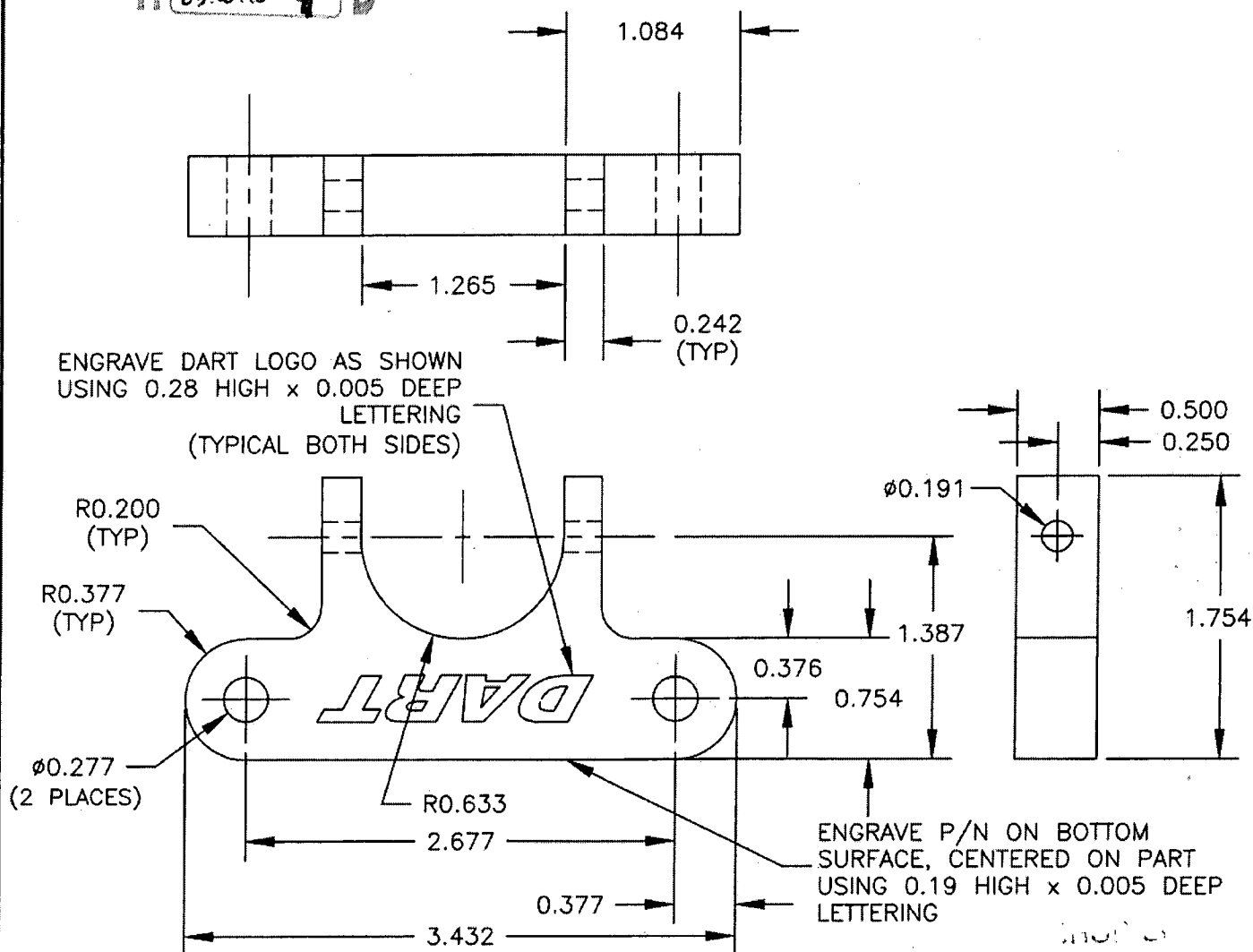
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CHECKED	HH	APPROVED	HH	DRAWING NO. D3195	SHEET 2 OF 3
DATE	03.06.23	TITLE	BRACKET	SCALE	1:1

RELEASED  
03.10.10



**D3195-1 BRACKET**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8) SUBJECT TO (REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

CONTROL

DATE

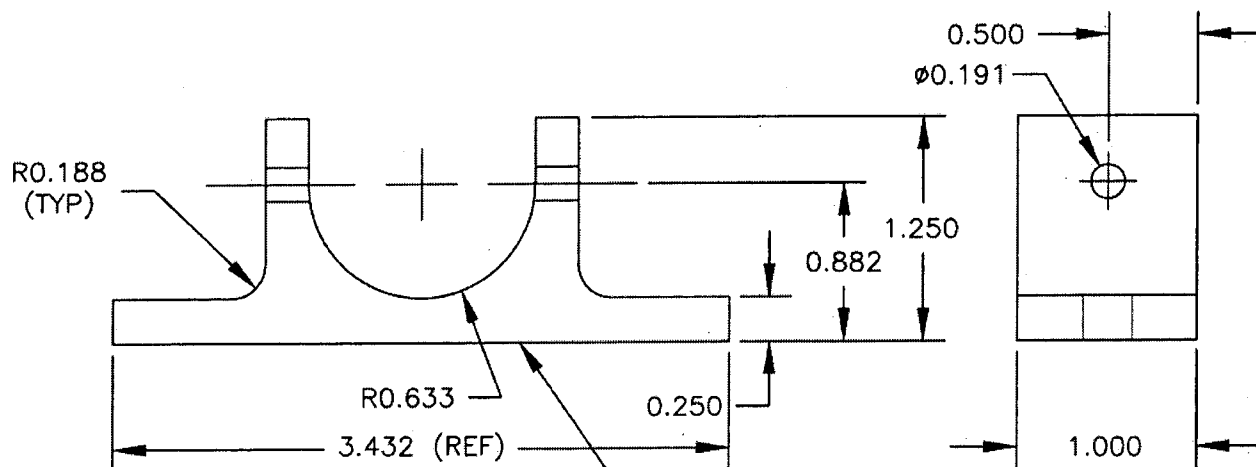
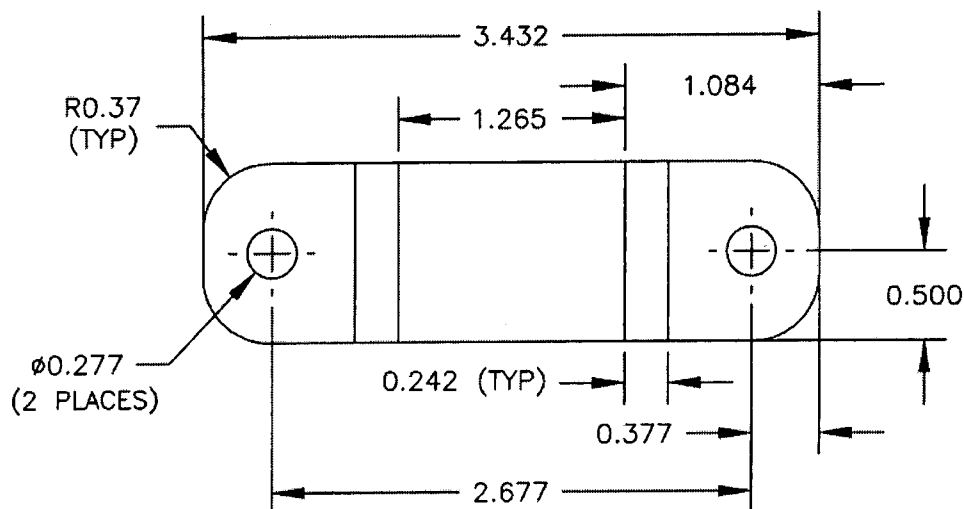
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				HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D3195
				REV. A SHEET 3 OF 3
DATE	03.06.23	TITLE	BRACKET	SCALE 1:1



RELEASED  
03.10.10

ENGRAVE P/N ON BOTTOM  
SURFACE, CENTERED ON PART  
USING 0.19 HIGH x 0.005 DEEP  
LETTERING

RETURN TO  
ENGINEER

#### D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

CONTROL  
DIRECT  
MILITARY

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